

PCT

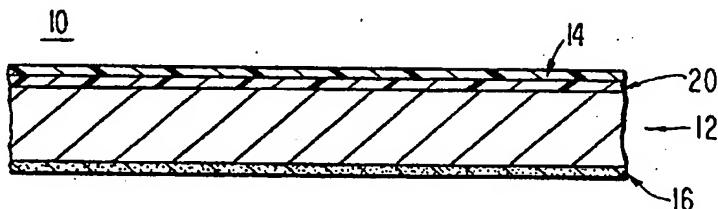
WORLD INTELLECTUAL PROPERTY ORGANIZATION
International Bureau



INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(51) International Patent Classification 5: B32B 5/24, 27/10, 9/04, B05D 3/02	A1	(11) International Publication Number: WO 94/26513 (43) International Publication Date: 24 November 1994 (24.11.94)
(21) International Application Number: PCT/US94/05161		(81) Designated States: AT, AU, BB, BG, BR, BY, CA, CH, CZ, DE, DK, ES, FI, GB, HU, JP, KP, KR, KZ, LK, LU, LV, MG, MN, MW, NL, NO, NZ, PL, PT, RO, RU, SD, SE, SK, UA, UZ, VN, European patent (AT, BE, CH, DE, DK, ES, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, ML, MR, NE, SN, TD, TG).
(22) International Filing Date: 9 May 1994 (09.05.94)		
(30) Priority Data: 08/059,790 10 May 1993 (10.05.93) US		
(71) Applicant: INTERNATIONAL PAPER COMPANY [US/US]; Two Manhattanville Road, Purchase, NY 10577 (US).		Published <i>With international search report.</i>
(72) Inventors: QUICK, James, R.; R.R. 1, P.O. Box 245, Greenwood Lake, NY 10925 (US). WENZEL, Donna, J.; 2-244B Robbins Road RD5, Middletown, NY 10940 (US). BARTHOLOMEW, Gene, W.; P.O. Box 251A Laurel Ridge, Sylvan Way, Tuxedo Park, NY 10987 (US). DE-LOZIER, Morton, S.; P.O. Box 165, Claryville, NY 12725 (US). KLASS-HOFFMAN, Maxine; 22 Park Avenue, Highland Mills, NY 10930 (US).		
(74) Agent: ONOFRIO, Dara, L.; Ostrager, Chong & Flaherty, 300 Park Avenue, New York, NY 10022-7499 (US).		

(54) Title: **RECYCLABLE ACRYLIC COATED PAPER STOCKS**



(57) Abstract

Recyclable paper stock comprising a substrate (12) coated on at least one surface with a water based emulsion coating (14). The water based emulsion coating comprises 20-90 dry wt. % of an acrylic-styrene copolymer and 5-70 dry wt. % of a wax. In another embodiment a second water based emulsion coating (18) comprised of an acrylic-styrene copolymer is coated on the substrate surface opposite the initial water based emulsion coating. The substrate may also be coated with a primer coat (20) prior to the application of the water based emulsion coatings to seal the substrate surface. The invention also includes processes for making and using the invented acrylic coated paper stocks.

FOR THE PURPOSES OF INFORMATION ONLY

Codes used to identify States party to the PCT on the front pages of pamphlets publishing international applications under the PCT.

AT	Austria	GB	United Kingdom	MR	Mauritania
AU	Australia	GE	Georgia	MW	Malawi
BB	Barbados	GN	Guinea	NE	Niger
BE	Belgium	GR	Greece	NL	Netherlands
BF	Burkina Faso	HU	Hungary	NO	Norway
BG	Bulgaria	IE	Ireland	NZ	New Zealand
BJ	Benin	IT	Italy	PL	Poland
BR	Brazil	JP	Japan	PT	Portugal
BY	Belarus	KE	Kenya	RO	Romania
CA	Canada	KG	Kyrgyzstan	RU	Russian Federation
CF	Central African Republic	KP	Democratic People's Republic of Korea	SD	Sudan
CG	Congo	KR	Republic of Korea	SE	Sweden
CH	Switzerland	KZ	Kazakhstan	SI	Slovenia
CI	Côte d'Ivoire	LI	Liechtenstein	SK	Slovakia
CM	Cameroon	LK	Sri Lanka	SN	Senegal
CN	China	LU	Luxembourg	TD	Chad
CS	Czechoslovakia	LV	Latvia	TG	Togo
CZ	Czech Republic	MC	Monaco	TJ	Tajikistan
DE	Germany	MD	Republic of Moldova	TT	Trinidad and Tobago
DK	Denmark	MG	Madagascar	UA	Ukraine
ES	Spain	ML	Mali	US	United States of America
FI	Finland	MN	Mongolia	UZ	Uzbekistan
FR	France			VN	Viet Nam
GA	Gabon				

"RECYCLABLE ACRYLIC COATED PAPER STOCKS"

5 Field of Invention

This invention generally relates to recyclable paper stocks and related methods of making the same useful as food packages or beverage containers having water resistance, grease resistance and limited moisture vapor transmission characteristics. More particularly, it concerns recyclable paper stocks comprised of a substrate coated on at least one surface with a water based emulsion coating. The water based emulsion coatings are readily recycled or breakdown more readily in a composting operation than conventional polyethylene or wax coatings.

Background Art

20 Polyethylene films and wax coatings which are generally laminated or coated to paper are widely used in packaging applications to protect products from moisture and provide water or grease resistance. However, recycling of packaging containing polyethylene films and wax coating are limited and costly since special 25 equipment is necessary for repulping. In addition, the polyethylene films and most wax coatings will not degrade if the package is composted.

The present invention provides recyclable paper stock comprised of a substrate coated on at least one 30 surface with a water based emulsion coating. The water based emulsion coatings include an acrylic-styrene copolymer and a wax component. In another embodiment a second water based emulsion coating including an acrylic-styrene copolymer is coated on the substrate surface 35 opposite the initial water based emulsion coating. The water based emulsion coatings of the invention are

-2-

readily recycled or more readily breakdown in a composting operation than conventional polyethylene films or wax coatings.

5 A search of the prior art has shown that acrylic latexes and wax coatings have been used in paper packaging applications.

U.S. Patent No. 3,874,905 to Knights discloses a process for coating liners of corrugated paperboards. The raw paper is coated with a styrene-butadiene rubber 10 latex, dried and cured. A heavier coating of paraffin wax is applied over the rubber coat to form wax coated paper products having water resistance.

U.S. Patent No. 3,981,434 to Ramich discloses a 15 carton for ice cream and frozen comestibles which contains a liner sheet made of a plastic film, such as polyethylene, or metallic foil. The interior surface of the paperboard carton is wax coated. The liner sheet is adhered to the interior surface of the carton by an adhesive which may be an acrylic latex adhesive or a 20 polyvinyl acetate adhesive which is preferred.

U.S. Patent No. 4,010,307 to Canard discloses production of gloss papers using coating compositions including styrene and butadiene copolymers and alkyl acrylate-styrene copolymers as binders.

25 Both U.S. Patent No. 4,471,904 to Cassidy and U.S. Patent No. 4,360,147 to Brauner disclose paperboard food cartons for fast food items in which the interior of the cartons, optionally, may be coated with aqueous modified acrylic coatings to provide a liquid moisture barrier and 30 grease resistance.

Finally, U.S. Patent No. 4,857,126 to Soremark discloses a process for making coated paper products including a release agent composition to decrease the adhesion of paper rolls during production. In the 35 production of corrugated board a first coating consisting

-3-

of the release agent, wax and acrylic polymer adhesive is applied to a paperboard substrate followed by a second coating of the release composition.

From the prior art mentioned it is seen that acrylic latexes have been used in paper packaging applications as an adhesive or to provide water resistance, and wax coatings are generally used to provide water resistance, however none of these references teach the combination of acrylic latexes, such as acrylic-styrene copolymers and wax as a water based emulsion coating to provide recyclable paper stock useful as a food package or beverage container, having water resistance, grease resistance and limited moisture vapor transmission characteristics. The invention is directed to the provision of such recyclable paper stocks. It would be appreciated that advantage over known applications would be obtained by providing acrylic coatings which are more readily recycled than polyethylene films and wax coatings.

Accordingly, it is a broad object of the invention to provide a recyclable paper stock comprised of a substrate coated with a water based emulsion coating, having water resistance, grease resistance and limited moisture vapor transmission characteristics.

A more specific object of the invention is to provide a recyclable paper stock comprised of a substrate coated with a water based emulsion coating including an acrylic-styrene copolymer and wax component.

Another more specific object of the invention is to provide a recyclable paper stock comprised further of a second water based emulsion coating including an acrylic-styrene copolymer on the substrate surface opposite the initial water based emulsion coating.

Another object of the invention is to provide a recyclable paper stock which is formed into a package or

-4-

container.

Another object of the invention is to provide a recyclable paper stock that complies with FDA regulations for food packaging and beverage container applications, 5 including the regulations pertaining to the packaging of aqueous and fatty foods.

Another object of the invention is to provide a recyclable paper stock that can be made into food packages or beverage containers on standard converting 10 machinery where seams, joints, end closures, etc. are formed by a heat sealing method such as hot bar sealing, hot air sealing or flame sealing. Alternately, the food packages or beverage containers can be sealed with hot melt adhesives or ultrasonically sealed.

15 A specific object of the invention is to provide a recyclable paper stock that can be manufactured without the dependence on extrusion coating equipment.

A more specific object of the invention is to provide a recyclable paper stock that is readily recycled 20 without dependence on special equipment for repulping.

Disclosure of Invention

In the present invention, these purposes, as well as 25 others which will be apparent, are achieved generally by coating at least one surface of a substrate with a water based emulsion coating comprised of 20-90 dry wt.% of an acrylic-styrene copolymer and 5-70 dry wt.% of a wax. Both the acrylic-styrene copolymer and wax component are 30 provided in an aqueous emulsion form. The acrylic-styrene copolymer has a glass transition temperature below 50°C. The wax component is selected from the group comprising paraffin wax, microcrystalline wax, polyethylene wax or a blend of two or more of said waxes. 35 The water based emulsion coatings may also contain

-5-

between 0-60 dry wt.% of an acrylic polymer having a glass transition temperature above 30°C.

5 In another embodiment of the invention, a second water based emulsion coating is applied on the substrate surface opposite the initial water based emulsion coating. This second water based emulsion includes an acrylic-styrene copolymer component and may also include an acrylic polymer with a glass transition temperature above 30°C.

10 Other additional components of the coatings may include thickening agents, defoaming or antifoaming agents, pigments, crosslinking agents, slip additives, release agents and antiblocking agents.

15 Substrates employed in the invention include a variety of coated and uncoated paper and paperboard, including bleached or unbleached, hardwood or softwood, virgin or recycled, and clay coated or uncoated forms of paper or paperboard. The basis weight of the substrates are in the range of 80 to 300 lbs per 3,000 sq. ft. and 20 the thicknesses range from 0.008 to 0.025 inches. A preferred substrate is paperboard and is selected from the group comprising bleached paperboard, clay coated bleached paperboard, unbleached paperboard or recycled paperboard.

25 The water based emulsion coatings are applied to the substrate surface as an aqueous emulsion. The aqueous water based emulsion coating is dried on the substrate surface to form a recyclable paper stock. The water based emulsion coatings have dry coating weights in the 30 range of 1 to 15 lbs. per 3,000 sq. ft.

35 The degree of penetration of the coatings into the substrate surface is dependent on the type of substrate used. A more porous substrate generally results in more penetration of the water based emulsion coating. However, in an embodiment of the invention the substrate

-6-

surface may be coated with a primer coat prior to the application of the subject water based emulsion coating. Generally, the primer coat is a water based coating and serves to seal a porous substrate surface. The primer 5 coat is generally comprised of a water based dispersion of a polymer selected from the group comprising acrylic polymers, acrylic copolymers, polyvinyl acetate, polyvinyl alcohol, poly-ethylene vinyl acetate, poly-ethylene vinyl chloride, styrene butadiene copolymers, 10 polyvinylidene chloride, starch or any other polymer which is capable of sealing the substrate surface. The aforementioned polymer dispersions may be combined with other materials to impart specific characteristics to the primer coat. For example, a pigment or mineral filler 15 such as clay may be used to provide improved leveling, smoothing and sealing of a rough or porous substrate.

The recyclable paper stock of the invention is formed into a food package or beverage container having water resistance, grease resistance and limited moisture 20 vapor transmission. In preferred applications the water based emulsion coating corresponds to a water-resistant internal surface of the package or container and the second water based emulsion coating corresponds to the external surface of the food package or container.

25 The coating on the substrate surface which corresponds to the interior surface of a package or container performs two primary functions. It provides properties required for the containment of liquids or frozen foods; water resistance, grease resistance, 30 limited moisture vapor transmission and FDA compliance. Second, it provides heat sealability so that the stock can be run on machines that produce packages with heat sealed seams, joints, end closures etc.

35 The additional coating or combination of coatings applied to the surface of the substrate which corresponds

-7-

to the outside surface of a package or container can provide printability, moisture resistance, enhanced heat sealability and other functional characteristics desired on the package exterior.

5 Other objects, features, and advantages of the present invention will become apparent from the following detailed description of the best mode of practicing the invention when considered with reference to the drawings, as follows:

10

Brief Description of the Drawings

FIGURE 1 is an illustration of a recyclable paper stock of the invention having a clay coated substrate and made in accordance with Example I;

15 FIGURE 2 is an illustration of a recyclable paper stock of the invention having a clay coated substrate, having two water based emulsion coatings and made in accordance with Example II;

20 FIGURE 3 is an illustration of a recyclable paper stock of the invention having two water based emulsion coatings and made in accordance with Example III;

FIGURE 4 is an illustration of a recyclable paper stock of the invention made in accordance with Example IV;

25 FIGURE 5 is an illustration of a recyclable paper stock of the invention having a two-sided clay coated substrate and made in accordance with Example V; and

30 FIGURE 6 is an illustration of a recyclable paper stock of the invention with a primer coat applied to the substrate and made in accordance with Example VI.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENT

35 In accordance with the invention as shown in FIGURES 1 to 6, recyclable paper stocks 10, are provided by coating at least one surface of a substrate 12, with a

-8-

water based emulsion coating 14, comprised of 20-90 dry wt.% of an acrylic-styrene copolymer and 5-70 dry wt. % of a wax.

Both the acrylic-styrene copolymer and wax component 5 are provided in an aqueous emulsion form. The acrylic-styrene copolymer component contains a combination of monomers including acrylic monomers, styrene and other copolymerizeable monomers. The acrylic-styrene copolymers used in the invention have a glass transition 10 temperature below 50°C.

Generally the acrylic-styrene copolymers are available commercially or on an experimental basis under various tradenames and from various manufacturers. For example Rhoplex®P-376, which is a preferred copolymer 15 used in the present compositions is an acrylic copolymer emulsion comprised of butyl acrylate, styrene and methacrylic acid and is available from Rohm and Haas, Independence Mall West, Philadelphia, Pennsylvania, 19105. Rhoplex®P-376 has a total solids content of 50%. 20 This acrylic-styrene copolymer has a glass transition temperature (Tg) of 21°C and a minimum film forming temperature of 8°C.

The wax component is selected from the group comprising paraffin wax, microcrystalline wax, 25 polyethylene wax or a blend of tow or more of said waxes. A preferred wax emulsion is Mobilcer® J which is a mixture of paraffin and microcrystalline wax and is available from Mobil Oil Corporation, 3223 Gallows Road, Fairfax, Virginia 22037-0001. This emulsion has a wax 30 melting point of 135°F.

The water based emulsion coating compositions may also include acrylic polymers having a glass transition temperature above 30° C present between 0-60 dry wt. %. A preferred acrylic polymer is Rhoplex B-85® which is an 35 acrylic polymer emulsion comprised mainly of methyl

-9-

methacrylate and is also available from Rohm and Haas. Rhoplex B-85® has a total solids content of 38%. This acrylic polymer has a glass transition temperature (Tg) of 109°C and a minimum film forming temperature of less 5 than 90°C.

The water based emulsion coating containing both an acrylic-styrene copolymer component and an acrylic polymer component provides production of a paper or paperboard package or container having good heat sealing 10 characteristics and blocking resistance. Generally, the presence of an acrylic-styrene copolymer provides good heat sealing characteristics while the presence of a harder acrylic polymer provides good blocking characteristics. Thus, the present invention 15 formulations combine the two components to achieve both desired results.

Other additional components of the coatings may include thickening agents, defoaming or antifoaming agents, pigments, crosslinking agents, slip additives, 20 release agents and antiblocking agents. A preferred polymer thickener used in the invention, as illustrated in the examples, includes Alcogum®L-36, an acrylic terpolymer emulsion, which is a reactive, acidic thickening agent of the type commonly referred to as an 25 in-situ thickener. Alcogum®L-36 is available from Alco Chemical (a division of National Starch and Chemical Company) P.O. Box 5401, 909 Mueller Drive, Chattanooga, Tennessee, 37406-0401. Also the defoaming agent used in the examples of the invention includes Foamaster®R 30 defoamer, available from Henkel Corporation, 300 Brookside Avenue, Ambler, Pennsylvania, 19002, and is comprised of 100% petroleum derivatives and other additives. It is generally insoluble in water but dispersible in surfactant systems.

35 Substrates employed in the invention include a

-10-

variety of coated and uncoated paper and paperboard, including bleached or unbleached, hardwood or softwood, virgin or recycled, clay coated or uncoated forms of paper or paperboard. The basis weight of the substrates 5 are in the range of 80 to 300 lbs per 3,000 sq. ft. and the thicknesses range from 0.008 to 0.025 inches. A preferred substrate is paperboard and is selected from the group comprising bleached paperboard, clay coated bleached paperboard, unbleached paperboard or recycled 10 paperboard.

The process of manufacturing the recyclable paper stock of the invention comprises the steps of applying a water based emulsion coating to at least one surface of a substrate and drying the emulsion coating on the 15 substrate to form the recyclable paper stock. The wet coating formulation, as applied to the substrate, is comprised of 15-90 wet wt.% of an acrylic styrene copolymer emulsion and 5-85 wet wt.% of a wax emulsion. The wet composition coating may further comprise between 20 0-75 wet wt. % of an acrylic polymer emulsion having a glass transition temperature above 30°C. The wet coating formulation also contains 30-80 wet wt. % of water which is removed in the drying step. The water based emulsion coatings of the invention have dry coating weights in the 25 range of 1 to 15 lbs per 3,000 sq. ft. Drying temperatures and line speeds are dictated by the drying characteristics of specific coating formulations, for example the % solids content, substrate basis weight and absorptivity, and equipment characteristics. Drying 30 conditions are controlled to prevent blistering of the coating and roll blocking or picking of the coating during rewinding of the coated substrate.

The water based emulsion coatings are applied to the substrate surface as an aqueous emulsion. The degree of 35 penetration of the coatings into the substrate surface is

-11-

dependent on the type of substrate used. A more porous substrate generally results in more penetration of the water based emulsion coating. However, in an embodiment of the invention the substrate surface may be coated with 5 a primer coat prior to the application of the water based emulsion coatings.

If a primer coat is used the substrate is coated in a two step process. The first step applies a primer coat that seals a porous substrate. The primer is applied 10 using conventional coating equipment such as rotogravure, flexographic, air knife, blade or Meyer rod coaters. The primer coat is generally dried prior to the application of the water based emulsion coating of the invention.

The primer coat is generally comprised of a water 15 based coating and will typically be of a different composition than the water based emulsion coating of the invention. The primer in itself decreases the penetration of the subject water based emulsion coatings into the substrate. Examples of materials that comprise 20 the primer coat are water based dispersions of a polymer selected from the group comprising acrylic polymers, acrylic copolymers, polyvinyl acetate, polyvinyl alcohol, poly-ethylene vinyl acetate, poly-ethylene vinyl chloride, styrene butadiene copolymers, polyvinylidene 25 chloride, or starch. However primers based on other polymers which are capable of sealing the substrate surface are also included. The aforementioned polymer dispersions may be combined with other materials to impart specific characteristics to the primer coat. For 30 example, a pigment or mineral filler such as clay may be used to provide improved leveling, smoothing and sealing of a rough or porous substrate.

In alternate embodiments of the invention, as shown in Figures 2 and 3, a second water based emulsion coating 35 is applied to a surface of the substrate opposite the

-12-

initial water based emulsion coating. This second water based emulsion coating is comprised of an acrylic-styrene copolymer. This second coating may also include an acrylic polymer with a glass transition temperature above 5 30°C.

The water based emulsion coatings of this invention may be applied to the substrate by any method of coating suitable for water based coatings. Examples of suitable coating methods include conventional methods such as air 10 knife coating, blade coating, metering roll coating, gravure coating, rod coating, curtain coating and spraying. Generally some type of elevated temperature drying will be required in order to dry the water based emulsion coatings at an acceptable production speed. 15 Suitable drying methods include hot air drying, infrared drying, direct flame drying and drying by contact with a heated drum.

The recyclable paper stock of the invention is formed into a food package or beverage container having 20 water resistance, grease resistance and limited moisture vapor transmission characteristics. In preferred applications the initial water based emulsion coating corresponds to an internal surface of the package or container and the second water based emulsion coating, 25 when used, corresponds to an external surface of the food package or beverage container.

As shown in the Examples below and in Figures 1 to 6, the water based emulsion coating 14, on the surface which corresponds to the interior surface of a package or 30 container performs two primary functions. It provides properties required for the containment of liquids or frozen foods; water resistance, grease resistance, limited moisture vapor transmission and FDA compliance. Second, it provides heat sealability so that the stock 35 can be run on machines that produce packages with heat

-13-

sealed seams, joints, end closures etc.

As shown in Figures 2 and 3, the optional coating 18, applied on the surface which corresponds to the outside surface of a package or container can provide 5 printability, moisture resistance, enhanced heat sealability and other functional characteristics desired on the package exterior.

The following Examples I through VI below, show various forms and compositions of the recyclable paper 10 stock of the invention. Specifically Example I illustrates a recyclable paper stock comprised of a clay coated substrate with a water based emulsion coating on the surface opposite the clay coating. Example II is comprised of a clay coated substrate with water based 15 emulsion coatings on each surface of the substrate. Example III is similar to Example II except the substrate is not clay coated. Example IV is similar to Example I except the substrate is not clay coated. Example V is similar to Example I except the substrate is clay coated 20 on both sides. Example VI is similar to Example I except a primer coat is applied to the substrate prior to the application of the water based emulsion coating. In Examples I to VI reference is made to corresponding Figures 1 to 6 which illustrate the construction of the 25 coated stocks as a package or container provided by each of the examples. These examples are merely representative and are not inclusive of all the possible embodiments of the invention.

EXAMPLE I

30 The substrate in this Example is comprised of a solid bleached sulfate (SBS) paperboard basestock from International Paper Company, Grade 1305, with a standard mill-applied clay coating on one surface of the substrate. The nominal basis weight of the basestock is 35 165 lb. per 3,000 sq. ft. and the nominal caliper

-14-

(thickness) is about 0.014 inches.

The following water based emulsion coating is applied to the substrate surface opposite the clay coating.

	<u>Composition Component</u>	<u>Approximate % Wet Coating Weight</u>
5		
10	° acrylic-styrene copolymer emulsion	70%
	°° acrylic polymer emulsion	10%
	°°° paraffin and microcrystalline wax emulsion	20%
	+ polymer thickening agent	0.2%
	++ defoaming agent	0.05%
15	-----	
	° Rhoplex® P-376 acrylic-styrene copolymer emulsion, by Rohm and Haas Company	
	°° Rhoplex B-85® acrylic polymer emulsion, by Rohm and Haas Company	
	°°° Mobilcer® J paraffin and microcrystalline wax emulsion, by Mobil Oil Corporation	
	+ Alcogum® L-36 acrylic polymer thickening agent in water, by Alco Chemical	
20	++ Foamaster® R defoaming agent, by Henkel Corporation	

The water based emulsion coating is dried on the substrate to form a recyclable paper stock shown in Figure 1. The water based emulsion coating has a dry coating weight of about 8-9 lbs. per 3,000 sq. ft. The resulting stock is suitable for the manufacture of beverage containers or food packaging. As shown in Figure 1 the water based emulsion coating 14 corresponds to the interior surface of a package or container and imparts water resistant characteristics on that surface. The clay coated surface 16 corresponds to the exterior surface of the package or container and is suitable for printing.

35

EXAMPLE II

The substrate in this Example is comprised of an SBS paperboard basestock from International Paper Company, Grade 1305, as described in Example I.

40 The following water based emulsion coating is applied to the substrate surface opposite the clay coating.

45

-15-

	<u>Composition Component</u>	<u>Approximate % Wet Coating Weight</u>
5	° acrylic-styrene copolymer emulsion	75%
	°°° paraffin and microcrystalline wax emulsion	25%
	+ polymer thickening agent	0.1%
	++ defoaming agent	0.05%
10	° Rhoplex®P-376 acrylic-styrene copolymer emulsion, by Rohm and Haas Company	
	°°° Mobilcer® J paraffin and microcrystalline wax emulsion, by Mobil Oil Corporation	
	+ Alcogum® L-36 acrylic polymer thickening agent in water, by Alco Chemical	
	++ Foamaster® R defoaming agent, by Henkel Corporation	

15 The water based emulsion coating is dried on the substrate and has a dry coating weight of about 8-9 lbs. per 3,000 sq. ft. A second water based emulsion coating is then applied over the clay coated surface of the substrate. The second water based emulsion coating 20 composition is as follows:

	<u>Composition Component</u>	<u>Approximate % Wet Coating Weight</u>
25	° acrylic-styrene copolymer emulsion	75%
	°° acrylic polymer emulsion	25%
	++ defoaming agent	0.05%
30	° Rhoplex®P-376 acrylic-styrene copolymer emulsion, by Rohm and Haas Company	
	°° Rhoplex B-85® acrylic polymer emulsion, by Rohm and Haas Company	
	++ Foamaster® R defoaming agent, by Henkel Corporation	

35 This second water based coating is dried on the substrate to form a recyclable paper stock shown in Figure 2. The second water based emulsion has a dry coating weight of about 1-2 lbs. per 3,000 sq. ft. The resulting stock is suitable for the manufacture of beverage containers or food packaging. As shown in 40 Figure 2 the water based emulsion coating 14 corresponds to the interior surface of a package or container and imparts water resistance and grease resistance on that surface. The second water based emulsion coating 18, applied on the clay coated surface of the substrate 16, 45 corresponds to the exterior surface of the package or container and provides moisture resistance on that surface.

-16-

EXAMPLE III

The substrate in this Example is comprised of an SBS paperboard basestock from International Paper Company, Grade 1339. Unlike, previous Examples I and II this substrate is not clay coated. The nominal basis weight of the basestock is 155 lb. per 3,000 sq. ft. and the nominal caliper (thickness) is about 0.014 inches.

The following water based emulsion coating is applied to one surface of the substrate.

	<u>Composition Component</u>	<u>Approximate % Wet Coating Weight</u>
10	• acrylic-styrene copolymer emulsion	50%
15	•• acrylic polymer emulsion	40%
	••• paraffin and microcrystalline wax emulsion	10%
20	+ polymer thickening agent	0.5%
	++ defoaming agent	0.05%
25	• Rhoplex®P-376 acrylic-styrene copolymer emulsion, by Rohm and Haas Company	
	•• Rhoplex B-85® acrylic polymer emulsion, by Rohm and Haas Company	
	••• Mobilcer® J paraffin and microcrystalline wax emulsion, by Mobil Oil Corporation	
	+ Alcogum® L-36 acrylic polymer thickening agent in water, by Alco Chemical	
	++ Foamaster® R defoaming agent, by Henkel Corporation	

The water based emulsion coating is dried on the substrate and has a dry coating weight of about 10-11 lbs. per 3,000 sq. ft. A second water based emulsion coating is applied on the surface of the substrate opposite the initial water based emulsion coating. The second water based emulsion coating composition is as follows:

	<u>Composition Component</u>	<u>Approximate % Wet Coating Weight</u>
35	• acrylic-styrene copolymer emulsion	50%
40	•• acrylic polymer emulsion	50%
	+ polymer thickening agent	0.5%
	++ defoaming agent	0.1%
45	• Rhoplex®P-376 acrylic-styrene copolymer emulsion, by Rohm and Haas Company	
	•• Rhoplex B-85® acrylic polymer emulsion, by Rohm and Haas Company	
	+ Alcogum® L-36 acrylic polymer thickening agent in water, by Alco Chemical	
	++ Foamaster® R defoaming agent, by Henkel Corporation	

50 This water based emulsion coating is dried on the substrate to form a recyclable paper stock shown in

-17-

Figure 3. The second water based emulsion coating has a dry coating weight of about 9-10 lbs. per 3,000 sq. ft. The resulting stock is suitable for the manufacture of beverage containers or food packaging. As shown in 5 Figure 3 the water based emulsion coating 14 corresponds to the interior surface of a package or container. The second water based emulsion coating 18, applied on the surface of the substrate opposite the initial water based emulsion coating, corresponds to the exterior surface of 10 the package or container.

EXAMPLE IV

The substrate in this Example is comprised of an SBS paperboard basestock from International Paper Company, 15 Grade 1334. Similar to Example III this substrate is not clay coated. The nominal basis weight of the basestock is 145 lb. per 3,000 sq. ft. and the nominal caliper (thickness) is about 0.0135 inches.

The following water based emulsion coating is 20 applied to at least one surface of the substrate.

	<u>Composition Component</u>	<u>Approximate % Wet Coating Weight</u>
25	• acrylic-styrene copolymer emulsion	54%
	•• acrylic polymer emulsion	27%
	••• paraffin and microcrystalline wax emulsion	10%
	water	9%
30	-----	
	• Rhoplex®-376 acrylic-styrene copolymer emulsion, by Rohm and Haas Company	
	•• Rhoplex B-85® acrylic polymer emulsion, by Rohm and Haas Company	
	••• Mobilcer® J paraffin and microcrystalline wax emulsion, by Mobil Oil Corporation	

35 The water based emulsion coating is dried on the substrate to form a recyclable paper stock shown in Figure 4. The water based emulsion coating has a dry coating weight of about 10 lbs. per 3,000 sq. ft. The 40 resulting stock is suitable for the manufacture of beverage containers or food packaging. As shown in Figure 4 the water based emulsion coating 14 corresponds

-18-

to the interior surface of a package or container and imparts water resistant characteristics on that surface.

EXAMPLE V

5 The substrate in this Example is comprised of an SBS paperboard basestock from International Paper Company, Grade 6816 with standard mill applied clay coatings on both surfaces. The nominal basis weight of the basestock is 201 lb. per 3,000 sq. ft. and the nominal caliper 10 (thickness) is 0.016 inches.

The following water based emulsion coating is applied to at least one of the clay coated surfaces of the substrate:

	<u>Composition Component</u>	<u>Approximate % Wet Coating Weight</u>
15	° acrylic-styrene copolymer emulsion	50%
	°° acrylic polymer emulsion	25%
20	°°° paraffin and microcrystalline wax emulsion	25%
	+ polymer thickening agent	0.4%
	++ defoaming agent	0.05%
25	° Rhoplex®-376 acrylic-styrene copolymer emulsion, by Rohm and Haas Company	
	°° Rhoplex B-850 acrylic polymer emulsion, by Rohm and Haas Company	
	°°° Mobilcer® J paraffin and microcrystalline wax emulsion, by Mobil Oil Corporation	
	+ Alcogum® L-36 acrylic polymer thickening agent in water, by Alco Chemical	
30	++ Foamaster® R defoaming agent, by Henkel Corporation	

30 The water based emulsion coating is dried on the substrate and has a dry coating weight of about 4 lbs. per 3,000 sq. ft. The resulting recyclable paper stock is suitable for the manufacture of beverage containers or 35 food packaging. As shown in Figure 5 the water based emulsion coating 14, corresponds to the interior surface of the package or container. The opposite clay coated surface 16 corresponds to the exterior surface of the package or container.

40

EXAMPLE VI

The substrate in this Example is comprised of solid bleached sulfate (SBS) paperboard basestock from International Paper Company, Grade 1305, as described in

-19-

Example I. This basestock has a standard mill applied clay coating on one surface. A primer coat was applied on the substrate surface opposite the clay coating. The primer coating was of the following composition:

	<u>Composition Component</u>	<u>Approximate % Wet Coating Weight</u>
10	• polyvinyl acetate emulsion	6.5%
	•• starch	3.2%
	••• clay	32.3%
	water	58.0%
	* crosslinking agent	0.08%
15	** dispersant	0.04%
	+ polymer thickening agent	0.2%

20	• NS®119 polyvinyl acetate emulsion from National Starch and Chemical, 10 Fineyne Ave., Bridgewater, New Jersey, 08807	
	•• PG®280 starch from Penford Products Co., P.O. Box 428, Cedar Rapids, Iowa, 52406	
	••• Hydrafine No. 1 clay from J.M. Huber Corp., Clay Division, Route 4, Macon, Georgia, 31298	
	* Parex®707 crosslinker from American Cyanamid Corp., One Cyanamid Plaza, Wayne, New Jersey, 07470	
	** Tamole®850 dispersant from Rohm & Haas Co.	
25	+ Alcogum® L-36 acrylic polymer thickening agent in water, by Alco Chemical	

25 The primer coating is dried on the substrate and has a dry coating weight of about 5 lbs. per 3,000 sq. ft. A water based emulsion coating is then applied over the primer coated surface. The water based emulsion coating is the same as the first water based emulsion coating described in Example III. The water based emulsion coating is dried on the substrate to form a recyclable paper stock as shown in Figure 6. The water based emulsion coating has a dry coating weight of about 7 lbs. per 3,000 sq. ft. The resulting stock is suitable for the manufacture of beverage containers and food packaging. As shown in Figure 6 the water based emulsion coating 14 is applied over the primer coat 20 and corresponds to the interior surface of a package or container and imparts water resistance to that surface. The clay coated surface 16 corresponds to the exterior surface of the package or container and is suitable for printing.

40 In Examples I to VI above, the recyclable paper stocks showed satisfactory liquid retention characteristics when formed into beverage containers. In

-20-

particular, cups for cold beverages, such as carbonated beverages, can be manufactured from the stocks provided by Examples I through VI. The heat sealability afforded by the initial water based emulsion coating, and 5 supplemented in some cases by a second water based emulsion coating, makes possible the manufacture of cups with heat sealed side seams and bottoms. Alternately cups can be manufactured from these stocks using a hot melt adhesive to seal the side seams and bottoms. A 10 suitable hot melt adhesive for this purpose is Macromelt®6211, a polyamide hot melt adhesive supplied by Henkel Corp., 5325 South 9th Avenue, La Grange, Illinois, 60525-3602. As another alternative, the seals may be formed by ultrasonic sealing. Cups manufactured from the 15 recyclable paper stocks of the invention exhibit a level of resistance to penetration by cold beverages in excess of that required for this application due to the inherent moisture resistance of the coating that includes an acrylic-styrene copolymer and a wax. All the Examples 20 described provide recyclable paper stocks which can be formed into beverage containers that are resistant to staining, exhibit no contamination of the beverage and comply with FDA regulations. In particular the recyclable paper stocks produced in Examples I, V and VI 25 also provide excellent printing characteristics on the exterior surface of the substrate having the clay coated surface. In Examples II and III the exterior surface of the substrate having the second water based emulsion coating exhibits superior moisture resistance. In Examples V and VI, where the water based emulsion 30 coatings are applied over a clay coating and a primer coating respectively, the water based emulsion coatings are smoother, glossier and have a higher integrity than the water based emulsion coatings of Examples I to IV.

35 In addition to beverage containers bakery trays and

-21-

boxes for baked goods such as breakfast pastries and coffee cakes can be manufactured from the recyclable paper stocks of Examples I through VI. The moisture resistance and grease resistance required for the 5 containment of baked goods is provided by the coating that includes an acrylic-styrene copolymer and a wax. This coating can be used for the interior surface of packages for the distribution and storage of bakery items. The other characteristics of the stocks of this 10 invention that have been described relative to beverage cups are equally relevant to the manufacture of packages for baked goods. Side seams, end flaps and other closures on bakery packages may be formed by heat sealing, hot melt gluing or ultrasonic sealing.

15 Repulping studies have been conducted to assess the recyclability of the paper stocks of the invention. The subject stocks can be repulped using standard equipment such as a hydropulper where the stock is mixed with water and subjected to a vigorous agitation. The stocks of the 20 invention can be redispersed without the use of elevated temperature or the addition of chemicals. Paper sheets formed from the redispersed material are free of fiber bundles and no pieces of the acrylic coating are evident, even when the sheets are examined under magnification.

25 When the stocks of the invention are compared with the corresponding basestocks without acrylic coatings, longer dispersion times are generally required for the acrylic coated stocks to achieve a comparable level of uniform fiber distribution in the recycled paper sheet.

30 Additional agitation of the mixture of fiber and water eliminates any difference between the results for the acrylic coated stocks and the uncoated basestocks. When the stocks of the invention are compared with conventional polyethylene coated stocks the superior 35 recyclability of the acrylic coated stocks becomes

-22-

evident. The polyethylene coated stocks will not provide acceptable recycled paper sheets regardless of the dispersion time because of the presence of large pieces of polyethylene film.

5 As described the substrate basestocks, water based emulsion coating compositions and water based emulsion coating weights of Examples I to VI are only representative of the various embodiments of the invention. The water based emulsion coating weights on
10 the substrate can be varied according to the requirements of the application being served. For instance, the coating weight on the interior surface of a package or container for certain applications could be much lower than 8-11 lbs. per 3,000 sq. ft. Also, other acrylic-
15 styrene copolymer emulsions, acrylic polymer emulsions and wax emulsions may be used instead of the Rhoplex® emulsions and Mobilcer®J emulsion. Additional coating composition ingredients may also be used including pigments, crosslinking agents, slip additives, release
20 agents or antiblocking agents.

The present invention provides two primary advantages over prior practice. First the invention provides a paper stock which can be recycled by conventional methods without any special measures to
25 remove polyethylene or wax coatings. The water based emulsion coatings of the invention breakup and disperse with the paper fibers when the material is run through a standard hydropulper. Second, the paper stock of the invention can be manufactured using machinery that can
30 handle only water-based coatings, eg. the coating sections on a paper machine, thus avoiding the need for polyethylene extrusion coating equipment or a waxing operation.

The utilization of conventional process lines and
35 the elimination of the need for special extrusion

-23-

equipment or wax coating equipment provide a low cost paper stock. It will be recognized by those skilled in the art that the paper stocks of the invention and process have wide application in the production of food packages or beverage containers having water resistance, grease resistance and limited moisture vapor transmission characteristics.

Advantageously, the paper stocks of the invention are less complex to manufacture than polyethylene coated stocks, and the subject paper stocks are more readily recycled than conventional polyethylene or wax coated stocks. Also, the paper stocks of the invention will breakdown more readily in a landfill or composting operation than conventional polyethylene or wax coated stocks.

Finally, variations of the water based emulsion coating compositions and coated products from the examples given herein are possible in view of the above disclosure. Therefore, although the invention has been described with reference to certain preferred embodiments, it will be appreciated that other composite structures and processes for their fabrication may be devised, which are nevertheless within the scope and spirit of the invention as defined in the claims appended hereto.

-24-

Claims

1. A recyclable paper stock comprising:
a substrate coated on at least one surface with a
water based emulsion coating;
5 said water based emulsion coating comprised of:
20-90 dry wt. % of an acrylic-styrene copolymer and
5-70% dry wt. % of a wax.
- 10 2. A recyclable paper stock as defined in Claim 1,
wherein said acrylic-styrene copolymer has a glass
transition temperature below 50°C.
- 15 3. A recyclable paper stock as defined in Claim 1,
wherein said water based emulsion coating further
comprises 0-60 dry wt. % of an acrylic polymer having a
glass transition temperature above 30°C.
- 20 4. A recyclable paper stock as defined in Claim 1,
wherein said substrate surface is coated with a primer
coat prior to the application of said water based
emulsion coating.
- 25 5. A recyclable paper stock as defined in Claim 4,
wherein said primer coat comprises a water based
dispersion of a polymer selected from the group
comprising acrylic polymers, acrylic copolymers,
polyvinyl acetate, polyvinyl alcohol, poly-ethylene vinyl

-25-

acetate, poly-ethylene vinyl chloride, styrene butadiene copolymers, polyvinylidene chloride or starch.

6. A recyclable paper stock as defined in Claim 4,
5 wherein said primer coat comprises a pigment or mineral
filler.

7. A recyclable paper stock as defined in Claim 1,
wherein said substrate is paperboard and is selected from
10 the group comprising bleached paperboard, clay coated
paperboard, unbleached paperboard or recycled paperboard.

8. A recyclable paper stock as defined in Claim 1,
wherein said substrate has a basis weight in the range of
15 80 to 300 lbs per 3,000 sq. ft. and a thickness in the
range of 0.008 to 0.025 inches.

9. A recyclable paper stock as defined in Claim 1,
wherein said water based emulsion coating has a dry
20 coating weight in the range of 1 to 15 lbs per 3,000 sq.
ft..

10. A recyclable paper stock as defined in Claim 1,
wherein said wax is selected from the group comprising
25 paraffin wax, microcrystalline wax, polyethylene wax, or
a blend of two or more of said waxes.

-26-

11. A recyclable paper stock as defined in Claim 1, wherein said substrate is a clay coated paperboard, wherein at least one surface of said substrate is clay coated.

5

12. A recyclable paper stock as defined in Claim 1, wherein said substrate is a clay coated paperboard, wherein both surfaces of said substrate are clay coated.

10

13. A recyclable paper stock as defined in Claim 1, further comprising a second water based emulsion coating coated on a surface of said substrate opposite said water based emulsion coating, wherein said second water based emulsion coating is comprised of an acrylic-styrene copolymer.

20

14. A recyclable paper stock as defined in Claim 13, wherein said second water based emulsion coating is further comprised of an acrylic polymer with a glass transition temperature above 30°C.

25

15. A recyclable paper stock as defined in Claim 13, wherein said substrate is a clay coated paperboard having at least one surface which is clay coated and said second water based emulsion coating is coated on said clay coated surface.

-27-

16. A recyclable paper stock as defined in Claim 1, which is formed into a package or container.

17. A recyclable paper stock as defined in Claim 5 16, wherein said water based emulsion coating is a water-resistant internal surface of said package or container.

18. A recyclable paper stock as defined in Claim 10 12, which is formed into a package or container, wherein said second water based emulsion coating is an external surface of said package or container.

19. A method of manufacturing a recyclable paper stock comprising the steps of:

15 providing a substrate;

applying a water based emulsion coating to at least one surface of said substrate;

wherein said water based emulsion coating is comprised of:

20 15-90 wet wt. % of an acrylic-styrene copolymer and 5-85% wet wt. % of a wax; and

drying said water based emulsion coating on said substrate to form the recyclable paper stock.

25 20. The method as defined in Claim 19, wherein said acrylic-styrene copolymer has a glass transition temperature below 50°C.

21. The method as defined in Claim 19, wherein said water based emulsion coating further comprises 0-75 wet wt. % of an acrylic polymer having a glass transition 5 temperature above 30°C.

22. The method as defined in Claim 19, comprising the further step of first applying a primer coat to said substrate surface and drying said primer coat on said 10 substrate prior to the application of said water based emulsion coating.

23. The method as defined in Claim 22, wherein said primer coat comprises a water based dispersion of a 15 polymer selected from the group comprising acrylic polymers, acrylic copolymers, polyvinyl acetate, polyvinyl alcohol, poly-ethylene vinyl acetate, poly-ethylene vinyl chloride, styrene butadiene copolymers, polyvinylidene chloride or starch.

20

24. The method as defined in Claim 22, wherein said primer coat comprises a pigment or mineral filler.

25. The method as defined in Claim 19, wherein said substrate is paperboard and is selected from the group comprising bleached paperboard, clay coated paperboard, unbleached paperboard or recycled paperboard.

-29-

26. The method as defined in Claim 19, wherein said substrate has a basis weight in the range of 80 to 300 lbs per 3,000 sq. ft. and a thickness in the range of 5 0.008 to 0.025 inches.

27. The method as defined in Claim 19, wherein said water based emulsion coating has a dry coating weight in the range of 1 to 15 lbs per 3,000 sq. ft..

10

28. The method as defined in Claim 19, wherein said wax is selected from the group comprising paraffin wax, microcrystalline wax, polyethylene or a blend of two or more of said waxes.

15

29. The method as defined in Claim 19, wherein said substrate is a clay coated paperboard, wherein at least one surface of said substrate is clay coated.

20

30. The method as defined in Claim 19, wherein said substrate is a clay coated paperboard, wherein both surfaces of said substrate are clay coated.

25

31. The method as defined in Claim 19, comprising

the further step of:

applying a second water based emulsion coating to a surface of said substrate opposite said water based

-30-

emulsion coating, wherein said second water based emulsion coating is comprised of an acrylic-styrene copolymer; and

5 drying said second water based emulsion coating on
said substrate to form the recyclable paper stock.

32. The method as defined in Claim 31, wherein said second water based emulsion coating is further comprised of an acrylic polymer with a glass transition temperature
10 above 30°C.

33. The method as defined in Claim 31, wherein said substrate is a clay coated paperboard having at least one surface which is clay coated and said second water based
15 emulsion coating is coated on said clay coated surface.

34. The method as defined in Claim 19, wherein said recyclable paper stock is formed into a package or
20 container.

35. The method as defined in Claim 34, wherein said water based emulsion coating is a water-resistant internal surface of said package or container.

25 36. The method as defined in Claim 30, wherein said recyclable paper stock is formed into a package or
container, wherein said second water based emulsion

-31-

coating is a external surface of said package or container.

37. The method as defined in Claim 34, wherein said
5 package or container is a cup.

38. The method as defined in Claim 37, wherein said cup is used to contain cold beverages.

10 39. The method as defined in Claim 34, wherein said package or container is a tray or box for baked goods.

40. The method as defined in Claim 34, wherein said recyclable paper stock is heat sealed.

15 41. The method as defined in Claim 34, wherein said recyclable paper stock is sealed with a hot melt adhesive.

20 42. The method as defined in Claim 34, wherein said recyclable paper stock is ultrasonically sealed.

1/3

10

FIG.1

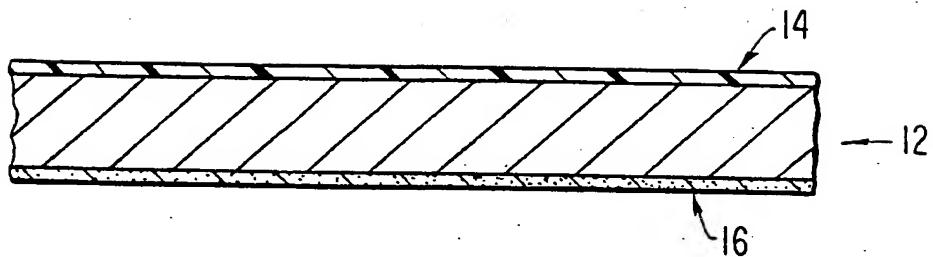
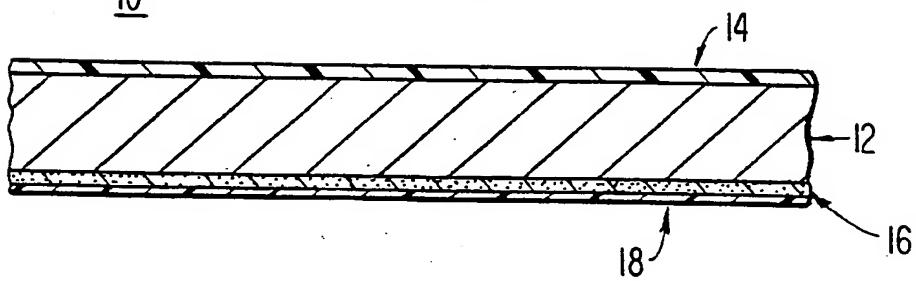
10

FIG.2



2/3

FIG.3

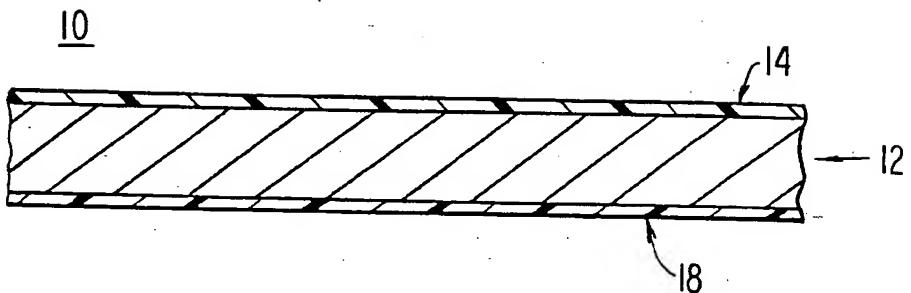
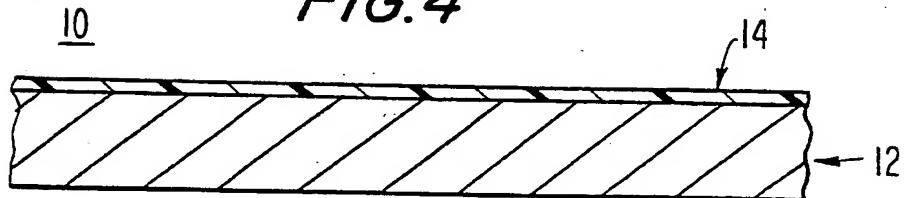


FIG.4



3/3

FIG.5

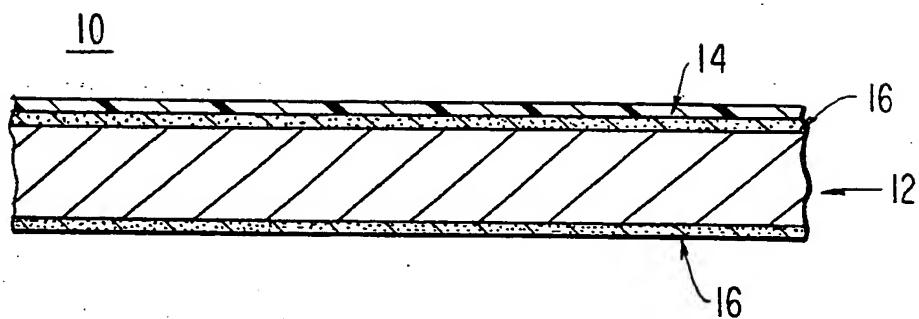
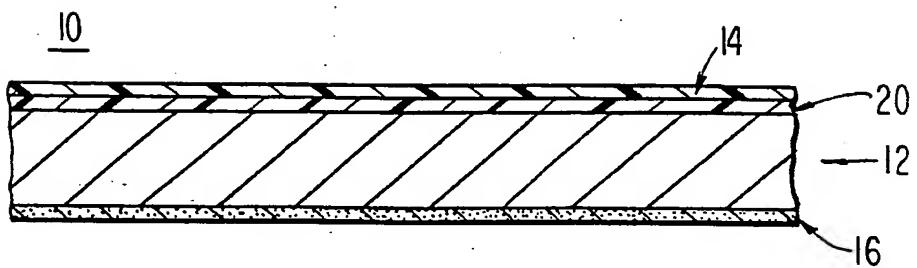


FIG.6



SUBSTITUTE SHEET

INTERNATIONAL SEARCH REPORT

International application No.

PCT/US94/05161

A. CLASSIFICATION OF SUBJECT MATTER

IPC(5) :B32B 5/24, 27/10, 9/04; B05D 3/02

US CL :428/311.1, 311.7, 481, 486, 903.3; 427/372.2

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

U.S. : 428/311.1, 311.7, 481, 486, 903.3; 427/372.2

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

NONE

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

NONE

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US, A, 4,714,727 (HUME, III) 22 December 1987, see entire document.	1-3, 7-10, 13, 14, 16-21, 26-28, 31, 32, 34-39
---		-----
Y		4-6, 11, 12, 15, 22-25, 29, 30, 33, 40-42
Y	US, A, 3,251,709 (BONZAGNI) 17 May 1966, see entire document.	4-6, 22-24
Y	ROHM & HAAS TECHNICAL BULLETIN, May 1991, "Products for Paper and Paperboard Coatings", see entire document.	4-6, 11, 12, 15, 22-25, 29, 30, 33

Further documents are listed in the continuation of Box C.

See patent family annex.

•	Special categories of cited documents:		
"A"	document defining the general state of the art which is not considered to be part of particular relevance	"T"	later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
"E"	earlier document published on or after the international filing date	"X"	document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone
"L"	document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)	"Y"	document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art
"O"	document referring to an oral disclosure, use, exhibition or other means	"&"	document member of the same patent family
"P"	document published prior to the international filing date but later than the priority date claimed		

Date of the actual completion of the international search

09 JUNE 1994

Date of mailing of the international search report

05 JUL 1994

Name and mailing address of the ISA/US
Commissioner of Patents and Trademarks
Box PCT
Washington, D.C. 20231

Facsimile No. (703) 305-3230

Authorized officer
BLAINE R. COPENHEAVER
Telephone No. (703) 308-2351